

Date: Thursday, 6/29/2006 10:54:13 AM
User: Kim Johnston

Process Sheet

| | | | |
|-----------------------|---------------------------------------|------------------|------------------|
| Customer | : CU-DAR001 Dart Helicopters Services | Drawing Name | : PLUG |
| Job Number | : 27776 | | |
| Estimate Number | : 12470 | | |
| P.O. Number | : N/A | Part Number | : D3492047 |
| This Issue | : 6/29/2006 S.O. No. : N/A | Drawing Number | : D3492 REV PREL |
| Prsht Rev. | : NC | Project Number | : N/A |
| First Issue | : N/A Type : MACHINED PARTS | Drawing Revision | : PREL |
| Previous Run | : N/A | Material | : N/A |
| Written By | : <u>SEE COMMENT BELOW</u> | Due Date | : 7/6/2006 |
| Checked & Approved By | : <u>06/06/29</u> | Qty: | 10 Um: Each |
| Comment | : Est Rev:A New Issue 06-06-20 JLM | | |

Additional Product

Job Number:



Seq. #

Machine Or Operation:

Description :

1.0

M6061T6R0500

6061-T6 Round Bar .500"



Comment: Qty.: 0.0656 f(s)/Unit Total: 0.6563 f(s)

6061-T6 Round Bar .500"

(M6061T6R0500)

Batch: M 16991/305 M101421/2PCS J.F. 06/06/29 10

2.0

HARDINGE

HARDINGE CNC LATHE SMALL



Comment: HARDINGE CNC LATHE SMALL

1-Turn as per Folio FA644 & Dwg D3492

Dwg Rev: B

Folio Rev: OPERATOR

J.F. 06/06/29 10

3.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.F. 06/06/29 10

4.0

QC8

SECOND CHECK



Comment: SECOND CHECK

Ep 06/06/29 x 10

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Deburr

J.F. 06/06/29

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|---------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Mfg / Design Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|----------------------------------|----------------|---------------------------|------------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Design Mgr | Approval QC Inspector |
| | | | Initial Design Mgr | Action Description Design Mgr | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: SR Date: 06/08/2012

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Thursday, 6/29/2006 10:54:13 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PLUG

Job Number: 27776

Part Number: D3492047

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

SAD

06:07:05

(10)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3
(Flat End Only)

SC 06/07/19

DL

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M 07 20

(10)

9.0

NAS1611007

O-RING



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Qty Part Number Description Batch

1 NAS1611-007 O-RING

M101332

DL 06/07/20

(10)

10.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: Hand Finishing

2-Assemble O'Ring as per Dwg D3492 Applying some O'Ring Lube

A/R 55-O'Ring Lube Batch: M101223

DL 06/07/20

(10)

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

M

06 07 20

(10)

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

ST 303

PT 06.07.20

EP 15

DL

06/07/20

(10)

13.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Dale,
Return to

15.06.07.20

PH. for Confirmation

11.06.07.20

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|---------------------------------|--------------------------|
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| | | | | | | | |
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| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| | | | Initial Design Mgr | Action Description Design Mgr | Sign & Date | | | |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

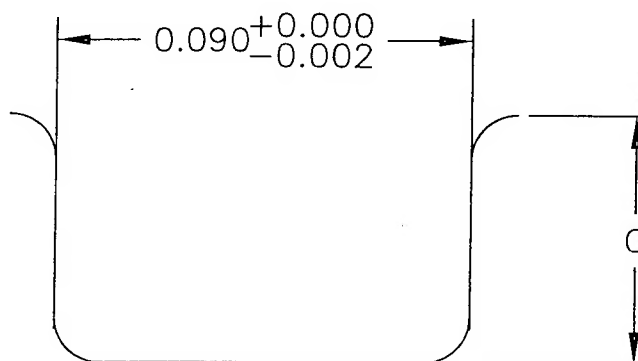
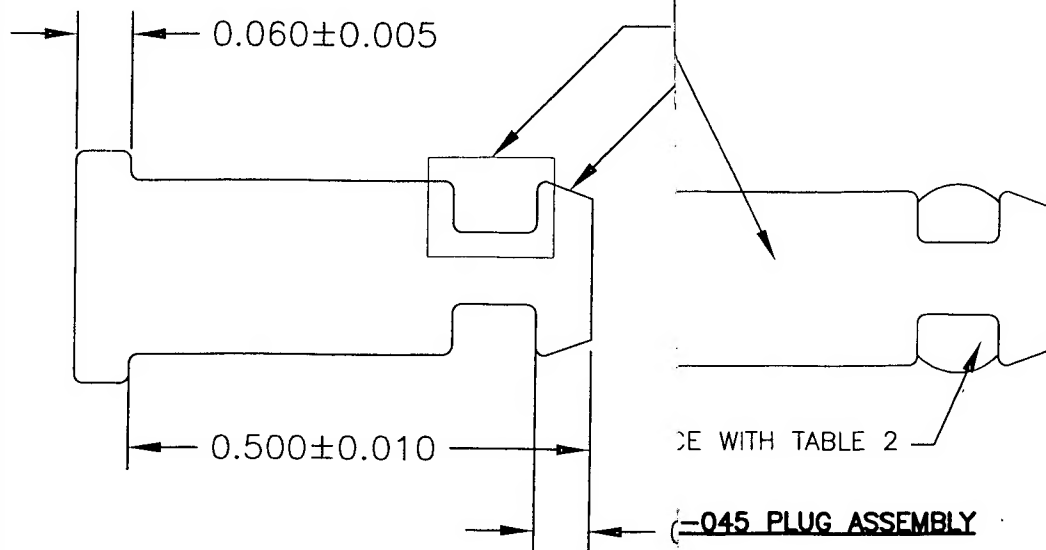
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____



GROOVE DETAIL

TABLE 1 D3492-1/-3/-5/-7 PLUG DIMENSIONS

| P/N | A | B | C |
|---------|-------|-------|-------|
| D3492-1 | 0.625 | 0.394 | 0.055 |
| D3492-3 | 0.750 | 0.582 | 0.045 |
| D3492-5 | 0.375 | 0.188 | 0.045 |
| D3492-7 | 0.500 | 0.270 | 0.045 |



D3492-1/-3/-5/-7 PLUG NOTES

- MATERIAL: ALUMINUM 5052-H32 OR 6061-T6
QQ-A-225/7 (5052) OR QQ-A-200/8 (6061) OR QQ-A-200/8 (6061) OR QQ-A-200/8 (6061)
(REF. DART MATERIAL SPECIFICATION)
- FINISH: ACID ETCH AND ALODINE P
POWDER COAT WHITE (4.35 MILS)
- ALL DIMENSIONS ARE IN INCHES
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE SPECIFIED
- BREAK ALL SHARP CORNERS 0.010 MAX

ASSEMBLY PARTS LIST

| Description |
|---------------|
| PLUG ASSEMBLY |
| PLUG ASSEMBLY |
| PLUG ASSEMBLY |
| PLUG ASSEMBLY |
| PLUG |
| PLUG |
| PLUG |
| PLUG |
| O-RING |
| O-RING |
| O-RING |
| O-RING |

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 27776

ADD -047; UPDATE DIM A, -045

NEW ISSUE

DART DART AEROSPACE USA, INC.
PORT HADLOCK, WA

DRAWING NO. D3492 REV. B
SHEET 1 OF 1

TITLE PLUG SCALE NTS

